SQS15 RIFLE
INSTRUCTIONS / SAFETY MANUAL

OPERATION, MAINTENANCE, AND TROUBLESHOOTING

⚠IMPORTANT

This manual contains operating, care, and maintenance instructions. To assure safe operation, any user of this firearm must read and understand this manual before using the firearm. Failure to follow the instructions and heed the warnings of this manual can cause property damage, personal injury, and/or death.

This manual can be found on our website at www.bcidefense.com/sqs15manual.

WARNING! Keep this firearm out of reach of children, unauthorized individuals, and anyone unfamiliar with safe handling of firearms.

MADE IN

USA

Thank You For Your Purchase

The BCI Defense (BCID) team thanks you for your purchase of this BCID Firearm. As a team we pour our passion for manufacturing, shooting sports, hunting, and the 2nd Amendment into every one of our firearms. Every firearm at BCID is manufactured and assembled by hand, so know that you have one of our personal firearms!

Happy SAFE Shooting.

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Warnings, Precautions, Remarks on Safety

Fundamentals of Safe Firearm Handling

1. ALWAYS keep your gun pointed in a safe direction.
2. ALWAYS keep your finger off of the trigger until ready to shoot.
3. ALWAYS keep the gun unloaded until ready to fire.
4. Know your target and what lies beyond.

Always assume your firearm is loaded and follow the above fundamentals.

Warning: Never rely on anything other than yourself for safety, including the gun mechanisms and those around you. Safe shooting and handling starts and ends with the operator.

Warning: Property damage, serious injury, or death may occur from the misuse of this firearm. Avoid carelessly or improperly handling this firearm to prevent avoidable accidental discharge.

Caution: Carefully read the User Manual for your firearm before unpackaging, loading, and using your new BCI Defense firearm. Strictly adhere to the instructions laid out in this manual to ensure safe operation.

Caution: Be sure to use only clean, undamaged, quality, commercially produced 5.56mm NATO or .223 Remington ammunition. BCI Defense strongly advises against the use of remanufacture, reloaded, or hand loaded ammunition in your firearms as they may cause damage.

Warning: Regardless of the position of the safety selector, or the position of the Bolt and Carrier, if a loaded magazine is in the weapon, a round could be chambered if the firearm is dropped or somehow impacted. Always be mindful of this possibility, and never store the weapon with ammunition.

Remarks on Dangerous Use

- Never fire the firearm with any barrel obstruction. This includes not only solid obstructions, but also liquid obstruction such as grease, oil, and water. Obstruction of the barrel may lead to increased barrel pressure. Over pressure can lead to cycling failures, or catastrophic failures such as barrel and chamber explosion.
- Always keep clear of the muzzle, especially during operation, loading, and failures. In the event of a problem, the last place to look is down the barrel of any firearm.
- If you experience a misfire under hot barrel conditions, remove the live round immediately to prevent the heat of the chamber from igniting the ammunition. If you are unable to do so, point the firearm in a safe direction, and allow the barrel to cool. During this time, be prepared for the firearm to discharge. Once cooled, safely remove the cartridge while adhering to all safety rules.
- Do not tamper with the internal mechanism of your firearm, only a competent gunsmith should ever adjust, replace, or tamper with firearm components. Failure to follow this guideline may result in a catastrophic firearm failure.
- If you notice an audible change in the firing of your weapon, or a difference in recoil, STOP FIRING AT ONCE. This may be an indication that there is a bullet impacted in the barrel, or you are experiencing incomplete powder burn. Clear the weapon completely before you resume firing.

About your BCI Defense SQS15

This user instruction booklet is provided with all SQS15 variants.

All of our firearms are chambered for 5.56mm NATO and .223 Remington Ammunition. Only these ammunition types should be used with your new SQS15.

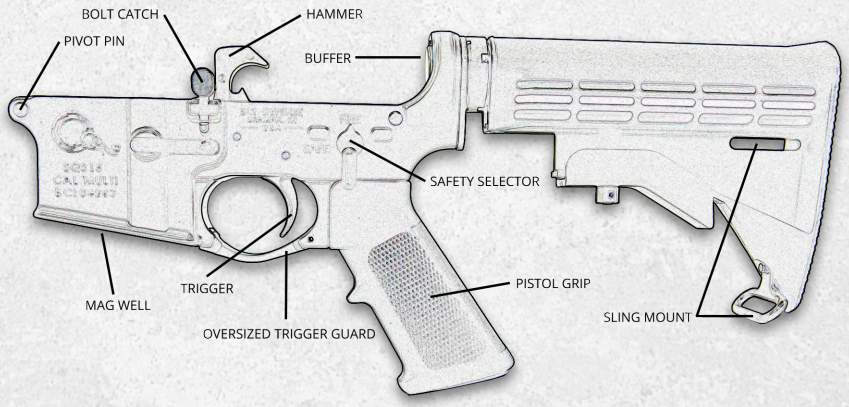
These firearms are light-weight modular firearm platforms with gas operation. They are Semi-Automatic in operation (for each trigger cycle, one and only one shot will be fired).

All of the BCI Defense firearms have both Upper and Lower Receiver components that are easily broken apart for cleaning and inspection. All SQS15 firearms are constructed of 7075-T6 aluminum receivers and buffer tubes.

SQS15 firearms are shipped with a 6 position SOPMOD stock and ergonomic pistol grip.

One 30 round magazine is shipped with your firearm. Any AR-15/M-16 magazine will fit and function as intended with your SQS15.

Introduction to Firearm Controls



Safety Checking and Clearing your Firearm

Please review the fundamentals of safe gun handling before you begin.

Always assume the gun you are handling is loaded, then follow the following procedure:

1. Maintain the firearm in a safe direction. Be sure the Safety Selector is on “SAFE”.

   Note: The Safety Selector cannot be engaged in the “SAFE” position unless the Hammer is in the cocked position.

2. Depress the Magazine Catch Button to release the Magazine. Pull the Magazine out and set it to the side.

3. Lock the Bolt open by pulling the Charging Handle fully to the rear, then press the bottom of the Bolt Catch into the Lower Receiver while slowly allowing the Charging Handle (and the Bolt) to move forward and come to rest on the Bolt Catch. Slide the Charging Handle back into the Upper Receiver and latch it. Double check that the Safety Selector is on “SAFE”.

4. Visually check that the Chamber is empty, and any rounds have been ejected.

Function Checking your Firearm

Safety Check your firearm before you begin. Instructions are in the previous section.

Verify once more that the Chamber is empty, and you have removed the Magazine.

1. Pull the Charging Handle rearward. Allow the Bolt and Bolt Carrier to move all the way forward. Do not pull the Trigger. The Hammer is in the cocked position.

2. Place the Safety Selector in the “SAFE” position, point the firearm in a safe direction, then pull the Trigger. The Trigger should not move, and the Hammer should not fall.

3. Move the Safety Selector to the “FIRE” position. When the Trigger is pulled, the Hammer should fall.

4. Pull the Trigger and keep it in the pulled position, pull the Charging Handle and release to cock the Hammer. Release the Trigger. The Trigger should return to the forward position. An audible click should be heard, and the Hammer should remain in the cocked position.

5. Repeat this test at least twice.

If the firearm fails any of these tests at any point, do not attempt to load or fire the weapon until it has been examined by a qualified gunsmith.

Loading your Firearm & Use of your Magazine

1. Only attempt to load quality commercially produced 5.56mm NATO or .223 Remington ammunition appropriate for your firearm. Be sure that each cartridge is clean, dry, and free of defects such as dents, gouging, and deformed case necks before loading them into your magazine. Do not use ammunition that fails to meet these requirements.

2. Insert ammunition with the primer end toward the end of the Magazine with the raised lips. The bullet end should be on the concave curve of the Magazine, while the primer end faces the convex side (when using the 30 round Magazine supplied, smaller capacity magazines will not have a curvature, and the retaining lips will be used as the only reference for proper loading).

3. Push the ammunition all the way to the rear of the magazine before inserting the next round in the same manner. Do not attempt to overfill your magazine.

Warning: Only load your magazine with live ammunition when you intend to shoot.

Chambering a Round

Caution: Only chamber a round when you are in a safe shooting environment and prepared to fire. Maintain a safe shooting direction.

1. With the Hammer cocked, move the Safety Selector to “SAFE”.

2. Pull the Charging Handle rearward. Make sure the Chamber is EMPTY.

3. Insert a loaded magazine with the ammunition pointing in the same direction as the muzzle. Tap the bottom of the magazine to ensure the Magazine Catch has clicked into place and the Magazine is fully inserted.

4. If the Bolt is open, be sure to keep fingers clear of the Ejection Port, and depress the Bolt Catch Release on the left side of the firearm. This will release the Bolt and Bolt Carrier, allowing it to move forward under spring tension and strip a round off of the top of the Magazine. The bolt will feed the round into the chamber, and lock.

5. If the Bolt is closed, keep fingers away from the Ejection Port, pull the Charging Handle all the way to the rear, and release. The Bolt under spring tension will rapidly move forward and feed a round into the Chamber

6. In the event that the Bolt does not completely lock into the Barrel Extension, tap the Forward Assist to move the Bolt forward into the locked position. (If the problem persists, have the gun inspected by a qualified gunsmith)

7. The firearm is now loaded and ready to be fired.

Firing the SQS15

Follow the instructions in the previous section on how to properly load and chamber a round in your firearm.

Caution: Your firearm is now loaded. Always keep the muzzle pointed in a safe direction, Safety Selector on “SAFE” and the Trigger area clear, until you are ready to fire.

To fire your Semi-Automatic firearm:

1. In a safe environment, aim the firearm downrange.

2. With the firearm shouldered, move the Safety Selector from “SAFE” to “FIRE”, keeping the Trigger area clear.

3. Aim the firearm at the target, move your finger onto the Trigger, and pull the Trigger to fire. Release the Trigger when complete.

The SQS 15 will have automatically removed the empty casing, and then chambered another live

round from your magazine (if another round is available). Cycling the Trigger mechanism will again fire the weapon. This sequence will continue until all of the loaded ammunition has been fired. At this point, the bolt will lock backwards in the open position. Put the Safety Selector on “SAFE”. Depress the Magazine Catch Button to remove the empty Magazine.

If you wish to stop firing before the magazine is empty:

1. After you fire your last desired round, immediately switch the Safety Selector to “SAFE”.
2. Depress the Magazine Release Button to remove the loaded Magazine.
3. Pull the Charging Handle back firmly to eject the live round from the Chamber.
4. With the Bolt in the rearward position, depress the bottom of the Bolt Catch to lock the Bolt Carrier in the rearward “open” position.
5. Your firearm is now empty.

Immediate Response in the Event of a Failure

If your firearm fails to fire:

1. Tap upward on the bottom of the Magazine to ensure it is seated properly in the Lower Receiver.
2. Pull the Charging Handle all the way rearward to eject the round. Make sure the round is ejected properly. Inspect the Chamber for to be sure it is clear.
3. Release the Charging Handle to chamber the next round. Never ease the Bolt forward manually, as this can cause the round to improperly feed, the Bolt not to lock, or other issue.
4. Tap the Forward Assist to make sure the Bolt is fully engaged in the Barrel Extension.
5. Safely fire the weapon.

If your firearm still does not fire:

1. Check again for a jammed cartridge case by clearing the Chamber.
2. If a cartridge is stuck in the Chamber, allow the gun to fully cool for at least 30 seconds with the muzzle pointed in a safe direction.
3. Once cool, remove the magazine and disassemble the Upper Receiver from the Lower Receiver. Remove the Bolt Carrier.
4. Insert a cleaning rod in the muzzle and attempt to gently remove the casing.

If the firearm still does not fire, clear the weapon and have it inspected by a qualified gunsmith.

In the event of a bullet stuck in the bore, do NOT follow the previous instructions, as firing a second bullet into an obstructed barrel can lead to a catastrophic failure, and potentially serious injury or death.
Instead:

1. Remove the Magazine by depressing the Magazine Catch Release Button.
2. Pull the Charging Handle rearward and lock the Bolt open.
3. Switch the Safety Selector to “SAFE”.
4. Remove the Upper Receiver from the Lower Receiver
.
5. Use a cleaning rod to check for a bullet stuck in the bore.
6. If you discover a barrel obstruction, take it to a qualified gunsmith for proper removal.

Front and Rear Sights

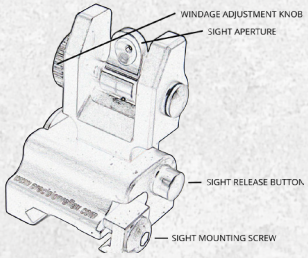
Your SQS15 firearm may be equipped with one of two different front sights:

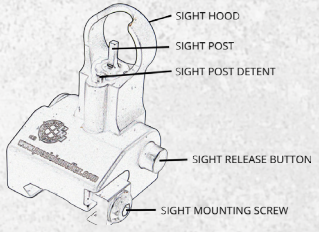
1. Combination Gas Block and Fixed Front Sight Post (A2 Front Sight)
2. Flip-Up Front Sight

Your SQS15 Firearm may be equipped with a flip-up dual-aperture Rear Sight, or may be ‘sight ready’, allowing you to purchase your own rear sight and/or attach your own optics.

Both Front Sights are adjustable for elevation, and the Rear Sight is adjustable for windage.

The Rear Sight has a “Short Range” aperture and an “Extended Range” aperture.



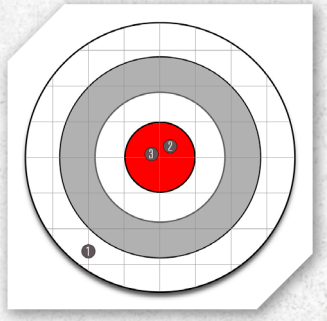


Sighting in your SQS15

Following the procedure listed in this section will zero your iron sights for point of aim/point of impact at 25 and 300 meters.

1. Set up a 25 meter paper Sighting Target at a 25 meter distance.

2. Flip the Rear Sight to the smaller aperture, and then move the aperture to the center of the sight by turning the knob on the right of the sight. There are markings on the rear of the sight base to assist you in finding your “Mechanical Zero Windage”.



3. On a clear range, carefully aim and fire 3 shots while using the sights to aim at the center of the target.

4. Examine the target.

5. If your shot group is too high or too low, that correction is made at the Front Sight Post. To raise your group rotate the front sight post clockwise. To lower your group, rotate counter clockwise. A front sight adjustment tool is helpful, but adjustment can be achieved by using the tip of a bullet to depress the Front Sight Detent allowing the pin to turn freely. One click on the sight post will move the point of impact by one square on your zeroing target.

6. If your shot group needs to be adjusted left or right (windage), this is achieved by manipulating the dial on the Rear Sight. To move your point of impact to the left on the target, twist the knob to the left (rearward). To move the point of impact to the right, twist the knob to the right (forward).

7. Carefully aim and fire another 3 shot group. Steps 5 & 6 can be repeated until you achieve point of aim and point of impact consistency.

Disassembling your SQS15

1. Clear your firearm (instructions can be found in the preceding sections of this manual).

2. On the left side of the receiver, press in the takedown pin as far as it will go (A bullet can be used as an aide). Pull it the rest of the way through from the right hand side.

3. Pivot the Upper Receiver away from the Lower Receiver.

4. Push in the Pivot Pin the same way as the Takedown Pin.

5. Pull the Upper away from the Lower Receiver.

6. Pull back Charging Handle.

7. Remove the Bolt Carrier Group. Your BCID firearm contains an Enhanced Bolt Carrier Group manufactured by Leitner-Wise MFG.

8. Remove the Charging Handle by pulling it back until the retaining ears reach the relief notch. The Charging Handle will then drop free.

9. Push the Firing Pin Retaining Pin out only until further resistance is felt as the pin does not need to be removed from the carrier in order to remove the firing pin. This unique design prevents accidental loss of the pin in the field.

10. Drop the Firing Pin out of the Bolt by tilting the assembly Bolt-end up.

11. Push the Bolt into the Bolt Carrier (rearward position).

12. Rotate the Cam Pin 90° and remove it.

13. Remove Bolt from Bolt Carrier by pulling it straight out.

14. Remove Extractor Pin by pushing it out of the Bolt with a small punch or the tip of a bullet. Set the pin aside carefully.

15. Remove the Extractor with the spring and spring guide. Be careful not to allow the spring to pop out away from you.

16. With the Hammer in the cocked position, depress the Buffer Retainer and slowly allow the Buffer (under spring tension) to clear the Buffer Tube and Receiver. Pull the Buffer and Buffer Spring fully out and set them aside.

STOP: Only a qualified gunsmith should further disassemble this firearm.

Inspecting, Cleaning, and Lubricating your SQS15

Corrosion prevention starts with cleaning the firearm quickly after firing. Even if the firearm is not being fired, environmental humidity can cause corrosion. If you live in a temperate region, annual to biannual cleaning and lubrication is recommended. For tropical environments, or other environments with high humidity, a much more frequent schedule is suggested. Cleaning your gun up to twice a week may be necessary to ward off corrosion in very humid climates.

If your SQS15 gets wet for any reason, clean as quickly as possible to avoid corrosion and rust.

BCI Defense recommends the purchase of a high quality cleaning kit that includes a cleaning rod, patch holder, bore brushes, chamber brushes, a small handled brush with non abrasive bristles (a toothbrush will suffice), cotton bore patches, and a good Cleaner/Lubricant/Protectant (CLP).

Cleaning the bore:

1. Always use only appropriately sized bore brushes to clean your SQS15. Using an incorrect tool may lead to irreversible damage to the firearm.

2. Always clean the bore in the direction that the bullet travels (Chamber to muzzle).

3. The bore of the Barrel on your SQS15 is rifled. This means there is a series of Lands and Grooves running the length of the Barrel in a spiral fashion. You may find it difficult to push a bore brush from the Chamber to the Muzzle. It may be easier to insert the cleaning rod without the brush installed through the end of the Muzzle and install the brush once the rod is in place. This will allow you to pull the brush through the bore in the correct direction. Allow the rod to rotate as you pull it through the bore, the brush will want to follow the grooves of the rifling as it advances through the bore. This is called “tracking”. You want the brush to turn freely as it travels the length of the bore.

4. Assemble your cleaning rod sections if using a break-down rod. Do not fully tighten each joint, to allow for “tracking” as described earlier, you should leave each joint 2 turns short of fully tightened (If your cleaning rod handle swivels freely, this is not necessary).

5. Attach the patch loop or patch holder to the end of your assembled cleaning rod. As before, do not fully tighten the cleaning rod.

6. Hold the upper receiver in one hand and the cleaning rod in the other. Insert the rod handle end first into the chamber end of the bore. Be careful not to allow the rod or its components to scratch the walls of the bore.

7. Attach the handle to the end of the rod protruding from the Muzzle of the firearm.

8. Dab “CLP” onto a fresh patch, and thread the patch into the patch holder on the cleaning rod.

9. Swab out the bore with the patch.

10. Remove the patch, and patch holder (with rod in the barrel, patch holder protruding through the upper receiver).

11. Install the bore brush (again leaving it two turns short of tight).

12. Pull the brush slowly through the bore and out the muzzle. Allow the brush to “track” through the rifling (you should notice the rod rotating as you pull it out of the bore).

13. After the first pull, twist off the handle and reinsert that end of the rod into the chamber and push the rod through the bore until the handle can be reattached. Repeat the bore brushing process 3 or 4 times.

14. Check to be sure the rod has not “tracked” so much that the joints in the rod have become tight. If so, loosen them.

15. Repeat bore brushing procedure 3 additional times.

16. Occasionally swap a bore brush pass with a pass of a moist patch to clear any of the debris that the brush is loosening.

Warning: Only ever clean the barrel in one direction (chamber to muzzle).

Warning: Never run a bore brush through a bore prior to lubrication.

Cleaning the Upper Receiver:

17. During the cleaning process, take the opportunity to inspect the components for a tight fit. Attempt to twist the Barrel and the Upper Receiver by hand to detect looseness. Check to see that the Forward Assist is tight, and that the pin is properly in place. If looseness is detected, take the firearm to a qualified gunsmith.

18. Warning: Never use a metal or wire brush on your upper receiver. The receiver is constructed of aluminum, and harsh abrasives may cause irreversible damage. Wire brushes may also cause damage to the finish on your firearm. A toothbrush is a good alternative for light scrubbing and loosening up buildup.

19. Use a quality “CLP” (Cleaner/Lubricant/Protectant) on all areas of the receiver’s interior and exterior to remove grime, powder fouling, and any other corrosion or contaminant.

20. Clean the Chamber by dampening a chamber brush in “CLP” and insert the brush into the Chamber. At least 5 strokes in and out of the Chamber may be required to adequately clean it. After the strokes, twist the chamber brush around in the Chamber both clockwise and counterclockwise at least 5 times.

21. Use the bore brush with “CLP” to clean carbon buildup around the Gas Tube.

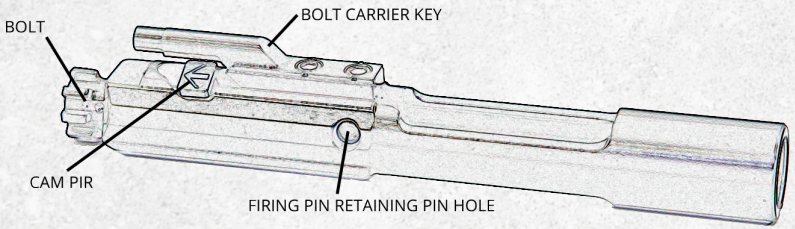
22. Run a pipe cleaner with “CLP” through the gas tube to clean carbon buildup on the inside.

23. With a cotton towel and “CLP” clean the Bolt Rings, Firing Pin, Bolt Cam Pin, Extractor, and inside of Bolt Carrier both where the bolt rides, and the rear of the Bolt Carrier.

24. Wipe every piece clean and dry.

25. While the firearm is disassembled, inspect each part for damage, excessive wear, corrosion, or mechanical failure.

- Check the Bolt. Look for cracks, especially around the Cam Pin socket. Inspect the Bolt Face for pitting near the firing pin hole.
- Check the Cam Pin. If it is cracked, gouged, chipped, or otherwise damaged, it should be replaced.
- Check the Firing Pin. A bent firing pin should be replaced. If the Firing Pin is too dull or sharp, that is indicative of wear. A worn firing pin should be replaced immediately.
- Check the Firing Pin Retaining Pin. Any pin that is worn, bent, gouged, etc. should be replaced. DO NOT REPLACE THIS PIN WITH A "HARDWARE STORE" COTTER PIN. The Firing Pin Retaining Pin is constructed of heat-treated spring steel with a flat head at the fold point. Using a standard cotter pin can cause severe damage.
- Check the Extractor Assembly. Any damage to the Extractor warrants immediate replacement. Check that the spring and the spring guide (inside the spring) are in good working shape and condition. Be sure to clean any residue on the backside of the Extractor, and from the spring to ensure smooth operation.



If you find damaged components, do not fire the weapon until the matter has been addressed by a qualified gunsmith.

Cleaning the Lower Receiver:

1. Use a quality "CLP" (Cleaner/Lubricant/Protectant) to remove powder fouling, grime, rust, and other corrosion from the surfaces inside and outside of the lower receiver on your SQS15.
2. Wipe the Trigger mechanism, the Magazine Catch mechanism, the bolt catch mechanism, and the Takedown and Pivot pins. Clean the Buffer, Buffer Spring, and Buffer Tube.
3. If necessary, the stock can be removed to allow cleaning of the Buffer Tube's Exterior, as well as the six holes on the bottom of the Buffer Tube utilized for adjusting the stock position. To remove stock, pull down on the adjustment lever (as opposed to up, as you would to adjust it). Slide the stock off to the rear of the firearm. Installation is the reverse.

Important Lubrication Points

Upper Receiver:

Apply a thin layer of lubricant to the inside of the Upper Receiver, the bore, and the Chamber. A thin layer should also be applied to exterior surfaces to ward off corrosion. To lubricate the Front Sight Detent, depress the pin and apply 2 drops to the area. Cycle the Detent up and down a few times to work in the lubricant.

Bolt Carrier Group:
Apply a thin layer of lubricant to the following components:

- Firing Pin (and Firing Pin cavity in Bolt)
- Extractor (and its pin)
- Charging Handle
- Bolt Carrier interior and exterior
- Bolt Carrier Key (dry with a Q-Tip, then apply one drop of CLP)

Apply a liberal amount of lubricant to the following components:

- Bolt
- Bolt Cam Pin (and Cam Pin socket)
- Bolt Gas Rings
- Rail area on Bolt Carrier where it contacts the Upper Receiver

Lower Receiver:

Apply a thin layer of lubricant to the inside of the Buffer Tube, Buffer Spring, and Buffer itself. Liberally lubricate each of the assemblies inside the receiver including the Trigger Group, Hammer Group, Safety Selector, Bolt Catch, Magazine Release, etc. Lubricate the Takedown and Pivot Pins also.

Be sure to wipe residue off of the Lower Receiver body to prevent corrosion. A black cloth for the final wipe down will not leave white lint behind.

Firearm Reassembly

After thoroughly cleaning and lubricating your firearm, follow these instructions to reassemble your firearm.

Bolt and Bolt Carrier Reassembly

1. Make sure the Extractor Spring Insert/Guide is in place, and the Extractor Spring is snapped into its respective socket on the interior of the Extractor Arm with the wide end of the spring in the socket.
2. Place the Extractor into the Extractor Recess on the Bolt and reinsert the Extractor Pin.

3. Examine the Gas Rings on the Bolt. Be sure the gaps in the three rings are evenly spaced around the circumference of the Bolt to minimize loss of pressure.

4. Install the Bolt into the Bolt Carrier. Insert the Bolt Cam Pin through the groove in the Carrier and then into the Bolt. Remember that the Cam Pin will only fit into the hole in the Bolt from one direction to ensure that the Extractor is on the correct side. If the Cam Pin does not go in easily, rotate the Bolt 180° inside the Bolt Carrier.

5. Once the Cam Pin is installed, twist it 90° in either direction to allow the Firing Pin to pass through.

6. Drop in the Firing Pin from the rear of the Bolt Carrier.

7. Pull Bolt out of the Bolt Carrier as far as you can (the Bolt will rotate and the Cam Pin will follow the path of the slot in the Bolt Carrier's top).

8. Push in the Firing Pin Retaining Pin.

Warning: Make sure all correct parts are installed properly, the absence of any of these components will result in an unsafe and unreliable firearm.

Installing the Bolt Assembly

1. With the Upper Receiver upside down, insert the Charging Handle into the Bolt cavity of the Upper Receiver and lower the flanges on the Charging Handle into their respective reliefs. Slide the Charging Handle partway into the track in the receiver.

2. With the Carrier Key in the track of the Charging Handle, lower the Carrier Assembly into the Upper Receiver. NOTE: the Bolt must be in the extended position during installation, or the head of the Cam Pin will not allow the assembly to fit into the Upper Receiver.

3. Slide the Bolt Carrier Assembly and the Charging Handle all the way into the Upper Receiver until the Charging Handle Latch clicks into place on the Upper Receiver.

Attaching Upper and Lower Receivers

1. Be sure both the Pivot Pin and the Takedown Pin are in the released position (protruding out of the Lower Receiver).

2. Position the Pivot Pin Lug on the front most part of the Upper Receiver into the slot at the front most part of the Lower Receiver and push the Pivot Pin into place until you feel and hear it click into place.

3. Check to be sure that the Safety Selector is placed on "SAFE".

4. Pivot the Upper and Lower Receivers together and push in the Takedown Pin.

Troubleshooting

For when you have trouble... shooting.

Problem	Inspect	Solution
Firearm Fails to Fire	Safety Lever	Place on “FIRE”
	Firing Pin Installation	Consult “Bolt Carrier Group Reassembly” section for proper installation of Firing Pin.
	Too much oil inside bolt and Firing Pin Recess	Use a small pipe cleaner to wipe away excess oil, reassemble as instructed in “Bolt Carrier Group Reassembly” section.
	Defective Ammunition	Discard defective ammunition.
	Corroded, Old, Dirty Ammunition	Remove and discard ammunition.
	Excessive buildup on Bolt	Clean the Bolt following the “Cleaning Instructions”.
	Corroded or fouled Firing Pin and Firing Pin Recess	Clean the Bolt Assembly as described in the “Cleaning Instructions” section.

Problem	Inspect	Solution
Bolt is Stuck	Dirty or Damaged Bolt	Clean the Bolt following the “Cleaning Instructions”, or see a qualified gunsmith.
Round not Extracted	Broken or Missing Extractor Spring	Take your firearm to a qualified gunsmith.
	Damaged, dirty, or corroded casing.	Follow the safety instructions in this manual on how to safely remove a stuck casing with your cleaning rod.
	Powder Fouling or other Chamber debris	Thoroughly clean the Chamber as instructed in the “Cleaning Instructions” section.
	Dirty Extractor	Clean the Extractor following the “Cleaning Instructions” section.
	Corroded or fouled Firing Pin and Firing Pin Recess	Clean the Bolt assembly as described in the “Cleaning Instructions” section.

Problem	Inspect	Solution
Round Not Extracted Cont’d	Seized Extractor	Remove and clean the extractor following the “Cleaning Instructions” section.
	Restricted Buffer Assembly	Clean the Assembly following the “Cleaning Instructions” section.
	Restriction of the Bolt and Bolt Carrier in the Upper Receiver	Remove and clean the Bolt Carrier and the inside of the Upper Receiver following the “Cleaning Instructions” section.
	Defective Ammunition	Discard defective ammunition.
	Excessive buildup on Bolt	Clean the Bolt following the “Cleaning Instructions”.
	Corroded or fouled Firing Pin and Firing Pin Recess	Clean the Bolt assembly as described in the cleaning section of this manual.

Problem	Inspect	Solution
Improper Chambering of Ammunition	Dirty Ammunition	Place on “FIRE”, clean or discard the ammunition.
	Dirty Magazine	Clean the Magazine following the instructions of the Magazine’s producer.
	Defective or Damaged Magazine	Discard and Replace the magazine.
	Overloaded Magazine	Remove extra rounds and retry.
	Dirty or Damaged Buffer	Remove Buffer Assembly.
	Assembly	Inspect and clean all components following the“Cleaning Instructions” section. If components are damaged, see a qualified gunsmith.
	Magazine not fully inserted.	Tap the bottom of the Magazine to ensure full insertion, an audible click will be heard.

Problem	Inspect	Solution
Double Feeding of Ammunition	Magazine	Replace defective magazine.

Problem	Inspect	Solution
Won't Chamber Ammunition Fully	Dirty or Damaged Ammunition	Clean or Replace Ammunition.
	Carbon in Chamber or gas tube area	Clean these areas following the "Cleaning Instructions" section.

Problem	Inspect	Solution
Bolt will not lock	Damage or Dirt on Barrel Locking Lugs	Clean the area as instructed in the "Cleaning Instructions" section. If damaged, see a qualified gunsmith.

Problem	Inspect	Solution
Short or Abbreviated Recoil	Positioning of gaps on Bolt Gas Rings	Evenly disperse the gaps in the Gas Rings around the circumference of the bolt. With three gaps, each gap should be 120° from the others.
	Dirty Bolt Carrier Key	Clean the Carrier key following the "Cleaning Instructions" section.

Problem	Inspect	Solution
Bolt Fails to Lock back on an Empty Magazine	Faulty Magazine	Replace magazine.
	Dirty or Damaged Bolt Latch assembly	Clean the area around the Bolt Latch, and manipulate the mechanism with your fingers to verify correct spring operation. Verify correct bolt operation and travel by pulling the charging handle all the way back. If it does not pull all the way back, then clean the Buffer Assembly following "Cleaning Instructions" section.

Problem	Inspect	Solution
Bolt Carrier Stuck Closed	Round Jammed between Chamber and Upper Bolt area, or improper feeding of ammunition	Drop the magazine out of the Lower Receiver. Check that the Safety Selector is on "SAFE". Staying clear of the Muzzle, pull back on the charging handle and tap the Buttstock on the ground. This should cause the bolt to unlock, and the cartridge to fall out of the chamber.

Maintenance in Extreme Conditions

Cold Climate: Clean and lubricate in a controlled environment. Do not subject a warm firearm to cold environments, as this can cause condensation within the mechanism, which could keep the firearm from functioning properly. Do not lay a warm firearm in snow or ice.

Warm Dry Climate: If the firearm is subject to sandy and/or dusty environments, use extra care when cleaning the mechanisms. Inspect the hard to reach and hard to see areas of the firearm for sand and debris. These areas include, but may not be limited to, the Bolt Lugs, Charging Handle Track, Buffer Tube, Trigger and Hammer cavity, as well as the internal parts of the Bolt Assembly. There are many small springs that actuate the detents that hold in place other components of the firearm. Take note of stiff or loose components that may be experiencing trouble due to interference of dirt and sand in the spring channels. Corrosion is less likely in these climates, so over-lubrication is not necessary as a preventative, in fact, only light lubrication is advised, as too much CLP can cause dust and sand to stick to the surfaces of your SQS15.

Warm Wet Climate: In these climates it is important to clean and lubricate your firearm more frequently. Depending on the climate, it may be necessary to clean the firearm twice per week in very humid environments, as this moisture can lead to and/or increase the rate of corrosion and rust. Inspect the hard to reach and hard to see areas of the firearm for rust and corrosion. These areas include, but may not be limited to, the Bolt Lugs, Charging Handle Track, Buffer Tube, Trigger and Hammer cavity, as well as the internal parts of the Bolt Assembly. Take note of stiff or loose components that may be experiencing trouble due to interference of rust or corrosion in the spring channels.

Rain and Snow: Never fire the weapon if there may be water in the barrel. An obstructed barrel can cause extreme barrel pressure, which may cause the gun to fail or even explode. Always drain water from the barrel if this occurs, and swab the barrel following the cleaning instructions included in this manual.

Warranty Information

BCI Defense, LLC Warranty
BCI Defense, LLC products are warranted to be free from defective materials and workmanship for the life of the product. BCI Defense's responsibility under this warranty shall be limited to repairing and/or replacing any product that is found to be defective (based upon the inspection by, and discretion of, BCI Defense LLC) in material or workmanship. This warranty is void for the following reasons: careless handling, abuse and misuse, unauthorized adjustments or modifications, use of improper ammunition, excessive or unreasonable use, ordinary wear and tear, rust or corrosion, and barrel obstruction. Repairs are warranted for the duration of the original warranty and applies only to factory built products. Wholesalers or dealers, unless authorized by BCI Defense in advance, are not authorized to make any warranty repair or adjustment on behalf of BCI Defense.

Record of Serial Number

Export of the commodities described herein is strictly prohibited without a valid export license by the U.S. Department of State, Office of Defense, Trade Controls, prescribed in the International Traffic in Arms Regulation (ITAR), Title 22, Code of Federal Regulations, part 120-130.

Serial Number Information

Model Number:_____

Caliber: _____

Record the serial number of your BCI Defense, LLC firearm!

Serial#_____

(When holding the firearm, the serial number is located on the left side of the lower receiver, engraved on the magazine well just under the model name)

Description of Firearm:_____

BCI Defense, LLC authorized dealer from which the firearm was purchased:

_____

Attach your Proof of Purchase Here:

Who We Are

BCI Defense, LLC. (BCID), located in Bremen, IN, was established in 2012 by James and JB Brown. BCID is wholly owned by Bremen Castings, Inc. (BCI), founded in 1939 and known worldwide as a leader in the machining and foundry industry. Five generations of the Brown family have lead BCI to success for over 75 years by being passionate about what they do, and devoting themselves to quality, consistency, and excellence above all else. BCI is a leader, meeting the highest standards of each of their many OEM clients. In addition to their passion for manufacturing, the Brown family has a deep connection to the 2nd Amendment, firearms, and hunting. BCI Defense is the result of these two passions.

Our Philosophy

Here at BCI Defense, we do not hold ourselves to the “Military Standard”.

We hold not only our components, but also our team, to a higher standard: The BCI Defense Standard. SQS stands for “Status Quo Sucks!” and is based on the management philosophy that was developed to drive continuous improvement and to instill the ideology of never settling for second best. We built this philosophy to surround ourselves with employees who dedicate themselves to this frame-of-mind, both at work and at home. This management style drives everyone in the company to challenge themselves on the job and in life to make tomorrow better than today. We display the letters “SQS” on our firearms to remind us to continually question the boundaries of perfection and consistently rise further above both “Military Standard” and the standards of our competitors. The result is a product imagined, designed, and produced for you under the finest scrutiny and the highest of expectations.